

ABSTRACT

An oil-impregnated sintered which does not damage rotating shaft and itself and has a high durability even in the case that the rotating shaft is inclined in the bearing by a large shear load applied thereto, and a method of manufacturing an oil-impregnated sintered bearing which exhibits center deviation-suppressing action of the bearing satisfactorily by accurately forming a bearing hole in an intermediate completely sintered are disclosed.

An oil-impregnated sintered bearing includes a cylindrical bearing hole formed in the bearing body made of a sintered metal to support a rotating shaft. The bearing hole has a journal part of which an inner surface as a friction surface has a constant diameter, and enlarged diameter parts that are provided on both sides of the journal part so as to be connected with the journal part and are formed in a tapered shape having diameters to be enlarged toward the tips thereof. A distance between a line extending along an inclined surface of one enlarged diameter part and an inclined surface of the other enlarged diameter part facing the inclined surface of the enlarged diameter part across the middle of the bearing body is substantially equal to the diameter of the rotating shaft. In addition, in the processes of manufacturing an oil-impregnated

sintered bearing, the bearing hole that includes the journal part having a constant diameter by pressing an inner circumferential surface of a cylindrical sintered body completely sintered is formed, and then the enlarged diameter parts so as to be connected with the journal part by re-pressing the inner circumferential surface of the cylindrical sintered body is formed.